



Dart Aerospace Ltd.
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D3152-041
Job Sheet 172240

Ship 26 FEB

Part No: D3152-041

Job Qty: 2 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/14/18

Job Tracking No:

Due Date: 2/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev:B Removed Purchasing 05-12-19 JLM IPP REV:C 15.01.29 seal made in house DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		2/22/18	0.00	0.00	Start Up Small Fab-1		FF
100	Small Fab	2 pcs		2/23/18	0.00	0.56	Small Fab-2		FF
110	QC	2 pcs		2/23/18	0.00	0.00	QC5		
120	Packaging	2 pcs		2/23/18	0.00	0.00	Packaging3-1	CA02	178-2-22 FEB 27 2018
130	QC21-SA	2 Ea		2/23/18	0.00	0.00	QC21		

Part Op 100 - Bond D3152-3 Seal to D3152-1 Bracket using RTV 732 per Dwg D3152. RTV 732 Black Batch: 1388008
Descriptions: Expiry: Identify as D3152-041
110 - QC5- Inspect part completeness to step on W/O
120 - Identify as per dwg & Stock Location:
130 - QC21- Final Inspection - Work Order Release

DAS
21
9-80

FEB 7 8 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3152-1	Bracket	2 Ea (1 ea)	90-Start up Operation	F129151
D3152-3	Seal	2 Ea (1 ea)	90-Start up Operation	F131844
				F140136

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	GA D3152-1	2	2	0
	CA002 D3152-3	2	17	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order: _____	DISPOSITION Re Use Suspected Unapproved
Part No. _____	
NCR No. _____	

Date : _____	Step #: _____
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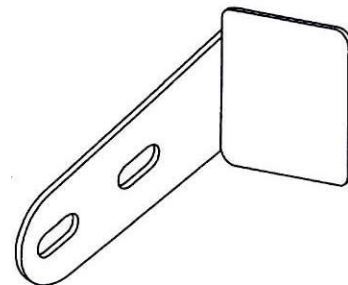
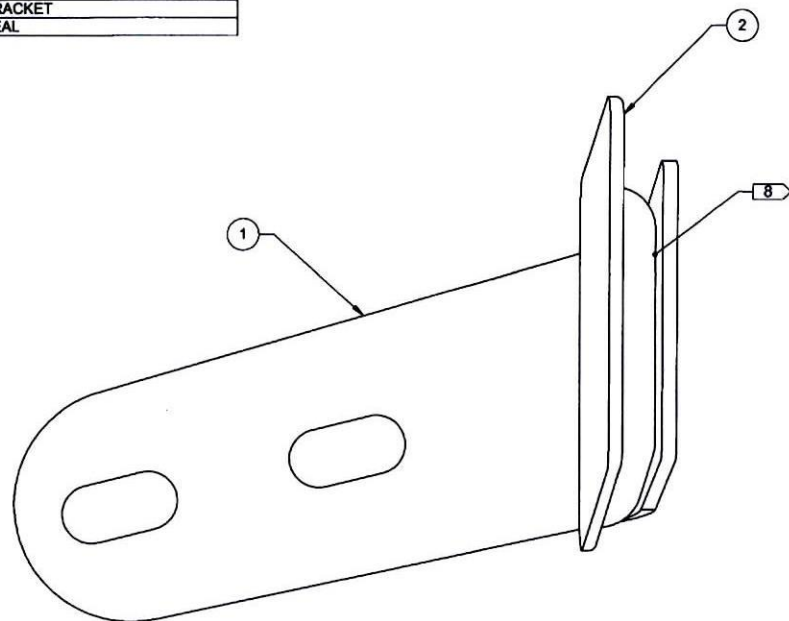
Description Work Order Deviation

QC / QA Coordinator
Approval

Root Cause				FAULT CATEGORY						
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							



ITEM	QTY -041	P/N	DESCRIPTION
	X	D3152-041	BRACKET ASSY
1	1	D3152-1	BRACKET
2	1	D3152-3	SEAL



D3152-041 BRACKET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172240 MJS
18-02-14

RELEASED
2015 FEB 13
ECN 14-63 4P

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) BOND D3152-3 SEAL TO D3152-1 BRACKET USING RTV 732 CLEAR (A/R) OR RTV 732 BLACK (A/R)

C	REVISE D3152-3/4 (MATERIAL), RE-FORMAT DRAWING, RE-DIMENSION D3152-1F	DB	14.10.28
B	ADD PART MARKING & RTV 732 BLACK	RF	04.10.18
A	NEW ISSUE	HS	02.04.24
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO. D3152	
MFG. APPR.	JLM		
APPROVED	HS	TITLE BRACKET ASSEMBLY	
DE APPR.	DS		
DATE	14.10.28	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

REV. C

SHEET 1 OF 5

SCALE

NTS

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____			DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved		AGAINST DEPARTMENT/PROCESS ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other						
Date :		Step #:			QTY Effective :				MRB (QSI042) Approval		
Description Work Order Deviation					Disposition					Completed By	
										Lead hand / Supervisor Approval Verification	
										QC / QA Coordinator Approval	
Root Cause ☐ Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due					FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence						
OTHER :											